

Work Order ID 105711

August-15-13 7:30:48 AM

105711

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Item ID: D2654-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 8/15/13 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/29/13 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MJS Date: 130813 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2654	F								
100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.00							
Skidtubes	1-Cut D2600-5 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends								
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00							
Hand Finishing									
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

① ② 138.5 2/3

① ② 138.5 2/3

4 ③ 13/08/15

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 Revision ID: Stop *NS2*
 Item Name: Web
 Start Date: 8/15/13 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/29/13 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>LG</u>	0.00				4	0	138.5	DL/13
140	Memo	0.00							
Packaging									
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150	Memo	0.00							
QC									
Quality Control									

13/8/20

MLJ 13-08-15

Picklist Print

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Parent Item: D2654-1

D2654-1

Parent Item Name: Web

Start Date: 8/15/13

Required Date: 8/29/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-080		Manufactured	No				Each	3.0000		4			
D2600-5-080									**				
Extrusion 'I Beam' thin													

Location

Loc Qty

Loc Code

LG

3

73867

1

90683

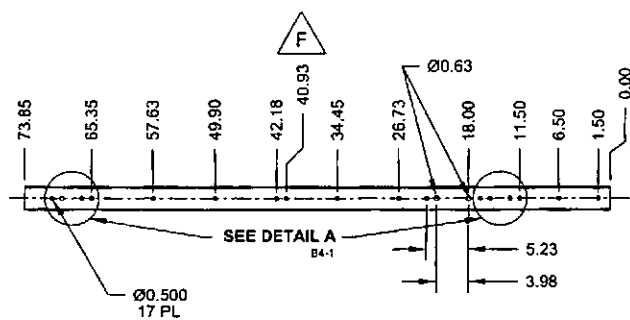
2

90684

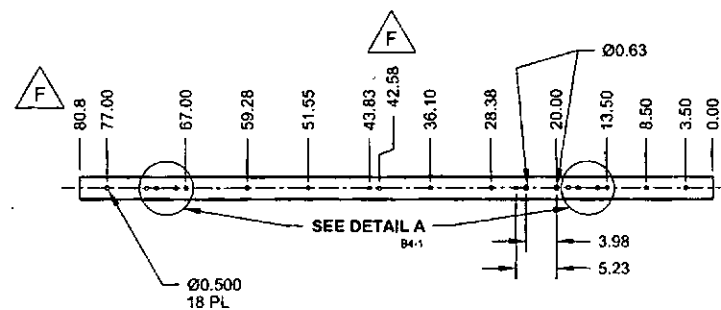
4

DL/B

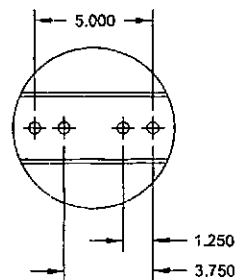
138-15



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C4-1
C5-1
C6-2
C7-2
C8-2

RELEASED
2011-09-12

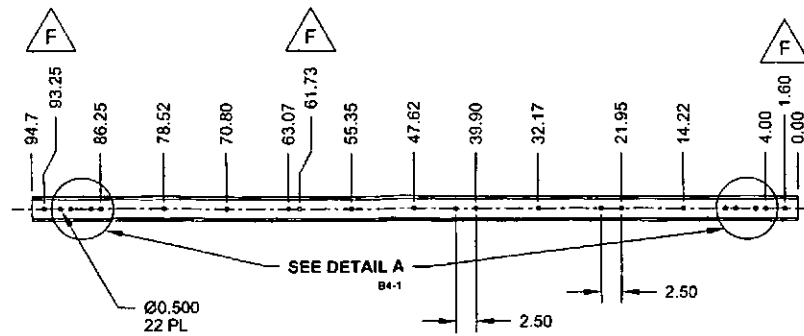
NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

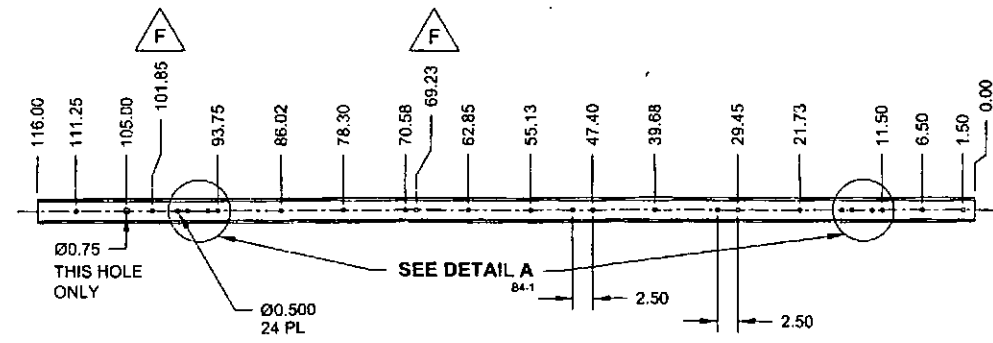
105711 MLD
13-08-15

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GIW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	GP	DRAWING NO.	REV. F
MFG. APPR.	GP	D2654	SHEET 1 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRINTED AND REPRODUCED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

10711



D2654-5 WEB



D2654-7 WEB

RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2654	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
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